

Work Order ID 72882

Wednesday, August 17, 2011 10:46:35 AM



Page 1

Item ID: D3536-35

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 8/17/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 8/19/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: CL Date: 11/08/17 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3536	Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

B11-8-17



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-8-17

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Suloski



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72882



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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

11/8/13 12

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/13 12

11-08-13 12

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Picklist Print

Wednesday, August 17, 2011 10:46:33 AM

Page 1

Work Order ID: 72882

Parent Item: D3536-35

Parent Item Name: Gasket



Start Date: 8/17/2011

Required Date: 8/19/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	223.0500	0.6197	8.262667			



NEOPRENE SHEET 0.063



1311-8-17

Location

Loc Qty

Loc Code

MAT052

223.05

117295

55.68

118026

167.37

118026

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	72882
Description: Gasket		Part Number:	D3536-35
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.25	+/-0.030	23.25	L		T 1B01	
19.75	+/-0.030	19.75	✓		T	
17.75	+/-0.030	17.75	✓		T	
14.25	+/-0.030	14.25	✓		T	
9.50	+/-0.030	9.50	✓		T	
4.75	+/-0.030	4.75	✓		T	
2.00	+/-0.030	2.00	✓		T	
6.00	+/-0.030	6.00	✓		T	
6.75	+/-0.030	6.75	✓		T	
0.30	+/-0.030	0.30	✓		V 1B02	
0.30	+/-0.030	0.30	✓		V	
1.89	+/-0.030	1.888	✓		V	
Ø0.19	+0.005/-0.001	0.191	✓		V	
0.063	+/-0.010	0.063	✓		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-8-17	Date: 11/08/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

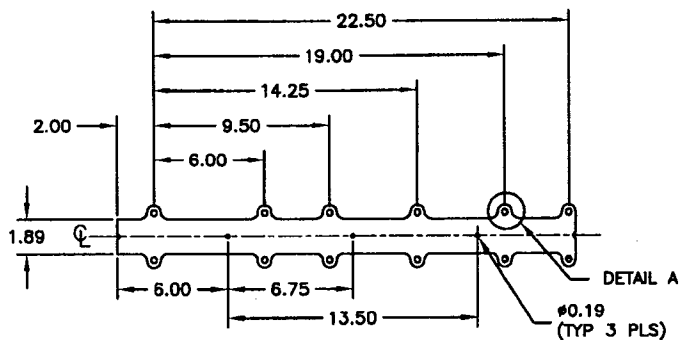
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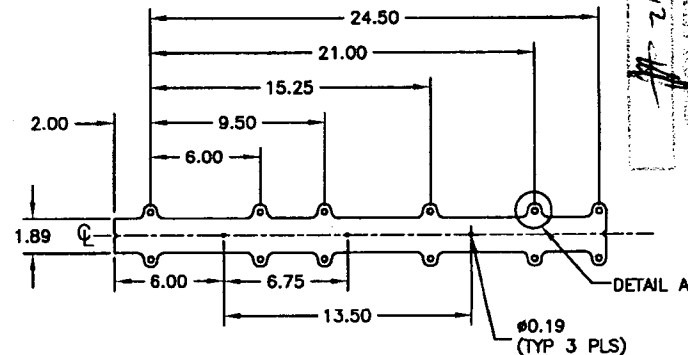
DART

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 4 OF 6
				SCALE
				1:10

07.02.12



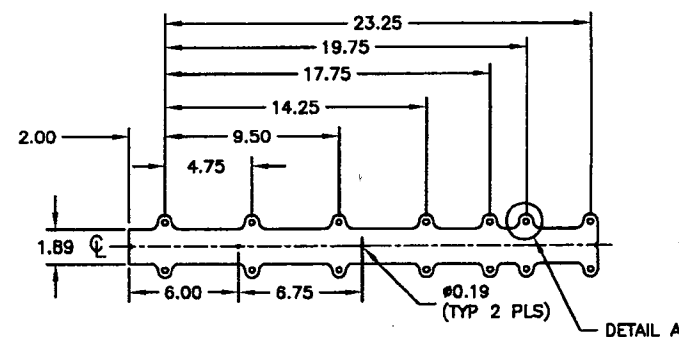
D3536-31 GASKET



D3536-33 GASKET

CL1108117

W10.72882



D3536-35 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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